

Date: Monday, 1/7/2008 11:35:55 AM  
 User: Kim Johnston

## Process Sheet

5

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: UTILITY BASKET LH/RH
Job Number	: 36603		
Estimate Number	: 10236		
P.O. Number	:	Part Number	: D350607047
This Issue	: 1/7/2008 S.O. No. :	Drawing Number	: D350-607 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: F
Previous Run	: 35937	Material	:
Written By	:	Due Date	: 1/31/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>Handwritten Signature</u>		
Comment	: Est Rev:B Re-Format 05-11-03 JLM Est Rev:C As per DSI9318 06-09-05 JLM Est Rev:D ECN1068 07-12-21 DD		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD350-607-047 ~~CHG001~~

CHG002

08/07/24

08.01.15

2.0	36603A	350 BASKET BASE (SHORT)
-----	--------	-------------------------



Comment: Sub-Component 350 BASKET BASE (SHORT)

D3265-041 B 36603A

08/07/24 ①

3.0	36603B	BASKET LID ASSEMBLY
-----	--------	---------------------



Comment: Sub-Component BASKET LID ASSEMBLY

D3267-043 B 36603B

08/07/24 ②

4.0	36603C	BASKET LID ASSEMBLY
-----	--------	---------------------



Comment: Sub-Component BASKET LID ASSEMBLY

D3267-041 B 36603C

08/07/24 ③

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick: Assembly Kit

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 1/7/2008 11:35:55 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UTILITY BASKET LH/RH

Job Number: 36603

Part Number: D350607047

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2022101

Spacer



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Spacer

Batch:

37521

SS of 6/7/23 (X)

7.0

D2258200

Weight Placard 200lb



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D2258-200

Label

37439

SS of 6/4/23 (X)

8.0

D2332041

Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D2332-041

Prop Ass'y

38797

SS

9.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D2530

Handle Weldment

40211

SS

10.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2535

Spring

37071

SS

11.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 D2537

Bushing

39153

SS of 8/6/23

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 1/7/2008 11:35:55 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UTILITY BASKET LH/RH

Job Number: 36603

Part Number: D350607047

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D27283

Dart Logo label large



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2728-3 Label 22553

13.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2931 Bumper 21139

14.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN3-16A Bolt M107737

15.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN4-13A Bolt 107959

16.0

AN422A

Bolt



Comment: Qty.: 7.0000 Each(s)/Unit Total : 7.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

7 AN4-22A Bolt M104937 x5 M107715 x2

17.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN5-17A Bolt M106815

08/07/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 1/7/2008 11:35:56 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UTILITY BASKET LH/RH

Job Number: 36603

Part Number: D350607047

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD8 Washer M107650.

SS

19.0

AN960JD416

Washer



Comment: Qty.: 14.0000 Each(s)/Unit Total : 14.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

14 AN960JD416 Washer M107939

SS

20.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416L Washer M108136

SS

21.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer M107959

SS

22.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer 108077

SS

23.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS20600AD4W3 Rivet 180831

SS of 167/23 (X)

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Monday, 1/7/2008 11:35:56 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UTILITY BASKET LH/RH

Job Number: 36603

Part Number: D350607047

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3)

M107665

JS

25.0

MS21042L4

Nut



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)

nut

Batch:

107478

JS

26.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L5 Nut (or -5)

M107939

JS

27.0

NAS1515H4

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch:

M106919

JS

0802/23

28.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D350-607

0806/24 @

29.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP.

0806/24 @

30.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick: Packing Kit

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 1/7/2008 11:35:56 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UTILITY BASKET LH/RH

Job Number: 36603

Part Number: D350607047

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

D22301

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-1

Lug

39319

AS

32.0

D22303

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 D2230-3

Clamp

39404

AS

33.0

D23241

Strut Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 \*D2324-1

Strut Ass'y

36749

AS

34.0

D2732

Rubber Extrusion



Comment: Qty.: 2.0000 f(s)/Unit Total : 2.0000 f(s)

Rubber Extrusion

8x D2732-030 (cut to 3")

Batch:

37632

AS

35.0

AN412A

Bolt



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

5 AN4-12A

Bolt

M105143

AS

36.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

2 AN4-13A

Bolt

M167959

AS

08/07/23 (X)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 1/7/2008 11:35:56 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: UTILITY BASKET LH/RH

Job Number: 36603

Part Number: D350607047

Job Number:



Seq. #:

Machine Or Operation:

Description :

37.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

Batch: M107737

JS

38.0

AN960JD416

Washer



Comment: Qty.: 26.0000 Each(s)/Unit Total : 26.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

26 AN960JD416 Washer 107939.

JS

39.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 13.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

13 MS21042L4 Nut (or -4) M107478.

JS 08/07/23 (XL)

40.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

JS 08/07/24 (XL)

41.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-607-047

Location: Rev B

JS 08/07/24 (XL)

42.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/24 (XL)

Job Completion



u 08-07-24

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. DSI 9318	REV. A SHEET 1 OF 1
DATE 06.01.06		TITLE WASHER ADDITION	SCALE NTS
A	06.01.06	NEW ISSUE	

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607 REV. F

REF. CANADIAN STC: SH94-14 ISSUE 4

REF. FAA STC: SR00213NY

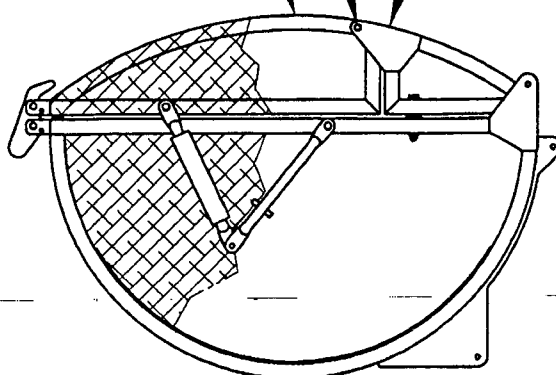
To reduce the possibility of damaging the finish, a **NAS1515H4** washer (2 places) has been added between the hinge plate and basket frame on the **D350-607-043/-047 Heli-Utility-Basket**.

The corrected bolt stackup from Figure 5 of installation instructions D350-607 Rev. F is given below:

AN4-13A BOLT (1)  
AN960JD416 WASHER (1)  
HINGE PLATE (REF)  
**NAS1515H4 WASHER (1)**  
BASKET FRAME (REF)  
AN960JD416 WASHER (1)  
MS21042L4 NUT (1)  
(2 PLACES)

BASKET FRAME (REF)

HINGE PLATE (REF)



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **36603**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 06.01.06  
CERT. NO.: SH94-14  
ISSUE NO.: 4

Copyright © 2006 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

Date: Monday, 1/7/2008 11:36:14 AM  
 User: Kim Johnston

## Process Sheet

5

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET LID ASSEMBLY
Job Number : 36603B	
Estimate Number : 10226	
P.O. Number :	Part Number : D3267043
This Issue : 1/7/2008 S.O. No. :	Drawing Number : D3267 REV B + 02939 REV B PD PTD 06.07.15
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 35937B	Material :
Written By :	Due Date : 1/31/2008 Qty: 1 Um: Each
Checked & Approved By : <u>08.01.07</u>	
Comment : Est Rev:C Removed -041 05-11-04 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
-----	----------------	---------------------------



U-065 PD 06.07.15



Comment: Qty.: 7.3500 f(s)/Unit Total: 7.3500 f(s)  
 3/4" x 3/4" x 0.063" wall 304/316 SS tubing  
 Batch: M108550

SAP 08/07/14

②

2.0	D31663	Basket Hoop
-----	--------	-------------



Comment: Qty.: 0.0000 Each(s)/Unit Total: 0.0000 Each(s)  
 Qty 1 D3166-3 Basket Hoop  
 Batch: B38780  
 Note: D3166-3 included in D3267-041 BOM

SAP 08/07/14

①

3.0	D31821	Hinge
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
 Pick:  

Qty	Part number	Description	Batch
2	D3182-1	Hinge	<u>B39336</u>

PD 08-07-18

4.0	D34423	Shim
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)  
 Pick:  

Qty	Part number	Description	Batch
2	D3442-3	Shim	<u>B37160 -&gt; 1x</u> <u>B26140 -&gt; 1x</u>

PD 08-07-18



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
03.07.15	2	HDD D2989 Rev B to w/o	PA	03.07.15	ALL	PA 03.07.15	N/A

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 11:36:14 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 36603B

Part Number: D3267043

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 4.5150 sf(s)/Unit Total : 4.5150 sf(s)

Pick:

Qty Part number

Description

Batch

4.300sf M304EX0.75-16F Expanded Metal

M108474

SAN 08/07/15

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing as per Dwg D3267

SAN 08/07/15 ①

2-Cut (4) D2236-1 From D3166-3

SAN 08/07/15

①

3-Drill holes in tubing D3267-043 as per Dwg D3267

SAN 08/07/15

①

4-Deburr & Remove All Markings From Material

SAN 08/07/15

①

5-Weld D3267-043 Assembly using Welding Table and corner Jig as per Dwg D3267. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid.

PD 08-07-15 ①

7.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

QC9 M08/07/23

QC5 08/07/03 ①

8.0

POWDER COATING

POWDER COATING



M108523



①X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M.1 08/07/23

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat

PH 08-07-23 PD

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/24 JH

Job Completion



U 08-07-24

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3267	REV. B SHEET 1 OF 2
DATE 05.06.08		TITLE BASKET LID ASSEMBLY	SCALE NTS
A	04.02.02	NEW ISSUE	
B	05.06.08	ADD SHIM UNDER HINGES	

RELEASED

05.08.19 *[Signature]*

**PARTS LIST:**

Qty -041	Qty -043	Part Number	Description
X		D3267-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D3267-043	BASKET LID ASSEMBLY (INSIDE)
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
2	2	D3265-3	STRUT
1		D3266-7	STRUT
2		D3267-1	STRUT
	2	D3442-3	SHIM

**NOTES:**

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBINGS (REF. DART SPEC M304TS0.750W.060)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT  
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36603 B

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER 30303B  
 NO. 30303B

SKIN BASKET LID WITH 3/4-16F EXPANDED SS, TACK WELD EACH END STRAND TO EXTERNAL FRAME

D2506 LABEL PLATE CENTER ON THE BASKET

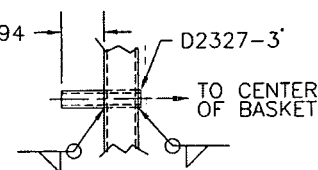
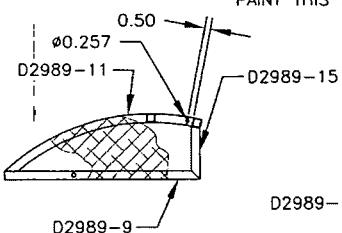
REMOVE 2" x 6" SECTION OF MESH FROM BEHIND LABEL PLATE

SEE DETAIL C (TYPICAL 2 PLACES)

TACK WELD EVERY 2ND STRAND TO INTERNAL FRAME MEMBERS

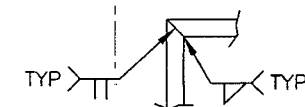
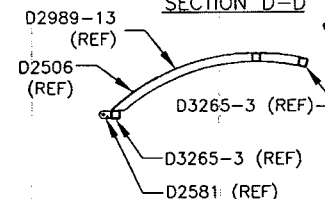
D2989-11 (REF)

BLACK ANTI-SKID PAINT THIS SECTION

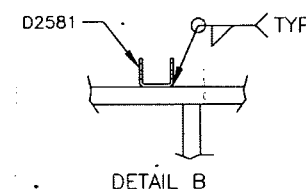


DETAIL C  
SPACER INSTALLATION

SECTION D-D



DETAIL A  
WELD ALL JOINTS AS SHOWN



DETAIL B

D3267-041 LID ASSEMBLY

SEE DETAIL A

D3265-3

TACK WELD EVERY 2ND STRAND TO INTERNAL FRAME MEMBERS

D2989-3 (REF)

D2989-4

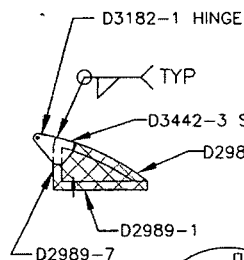
0.257 (TYP 5 PLACES)

D3265-3

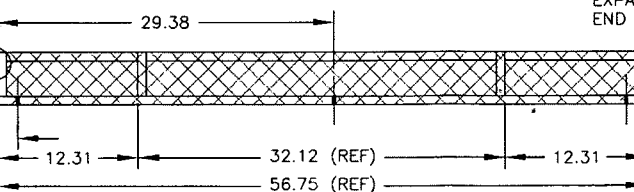
D2989-5

D2989-5

SKIN BASKET LID WITH 3/4-16F EXPANDED SS, TACK WELD EACH END STRAND TO EXTERNAL FRAME



DETAIL E



DETAIL E  
(SCALE 1:2)  
(TYP BOTH ENDS)

D3267-043 LID ASSEMBLY

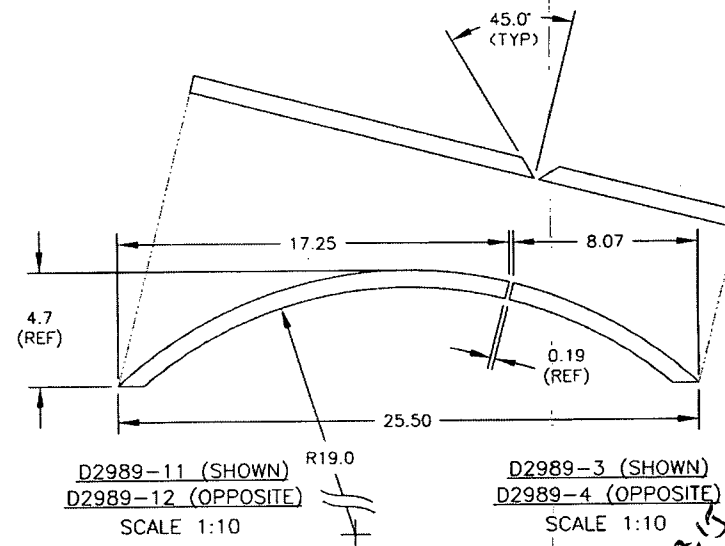
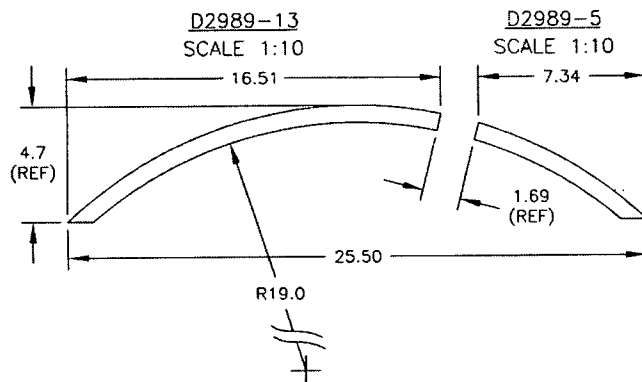
COPYRIGHT © 2004 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DESIGN	DS	DRAWN BY	PH	<b>DART</b>	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	#	APPROVED	#	DRAWING NO.	REV. B
DATE	05.06.08	TITLE	BASKET LID ASSEMBLY	D3267	SHEET 2 OF 2
		SCALE	1:10		

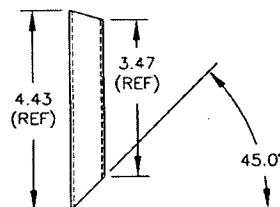
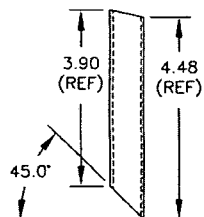
RELEASED

05.08.19

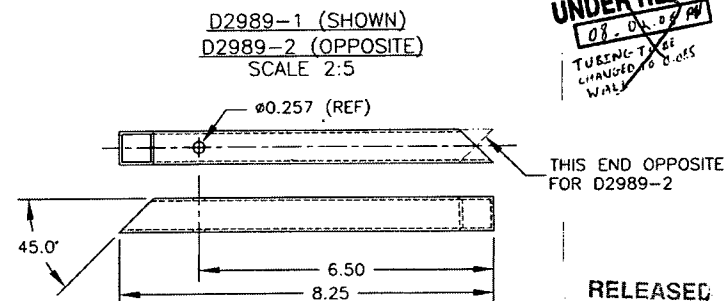
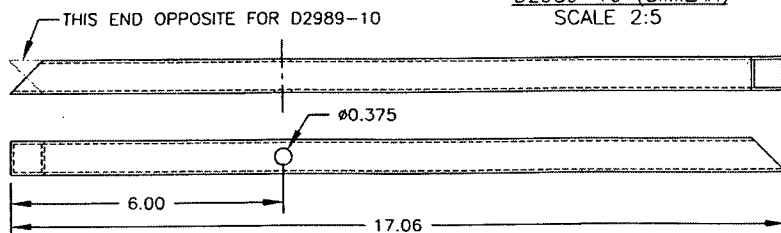


D2989-15  
SCALE 2:5  
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)

D2989-7  
SCALE 2:5  
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)



D2989-9 (SHOWN)  
D2989-10 (SIMILAR)  
SCALE 2:5



**UNDER REVIEW**  
08.04.07 PH  
TUBING TO BE  
CHANGED TO 0.005  
WALL

**RELEASED**  
05.08.19

COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN DS	DRAWN BY PH	<b>DART</b>	DART AEROSPACE LTD. WARRICKBURT, ONTARIO, CANADA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED #	APPROVED #	DRAWING NO. D2989	REV. B SHEET 3 OF 3
DATE 05.06.07		TITLE BASKET LID ASSEMBLY		SCALE 1:10	RETURN TO

ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36603B

Date: Monday, 1/7/2008 11:36:22 AM  
User: Kim Johnston

Process Sheet

5

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BASKET LID ASSEMBLY  
Job Number : 36603C  
Estimate Number : 10212  
P.O. Number :  
This Issue : 1/7/2008 S.O. No. :  
Prsht Rev. : NC Part Number : D3267041  
First Issue : 1/1 Type : LARGE FAB ASSY Drawing Number : D3267 REV B + 02989 Rev B PD  
Previous Run : 35937C Project Number : N/A PTO 01-07-15  
Drawing Revision : B  
Material :  
Due Date : 1/31/2008 Qty: 1 Um: Each  
Written By :  
Checked & Approved By : 080101  
Comment : Est Rev:C Removed -043 05-11-04 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 32.1300 f(s)/Unit Total : 32.1300 f(s)

3/4" x 3/4" x 0.063" wall 304/316 SS tubing M108250 (17.003)

Batch: M108663 (0.8681) M108550 (14.250) SAV 08/07/14 PD

2.0 D31663 Basket Hoop



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Qty 1 D3166-3 Basket Hoop

Batch: B38780 SAV 08/07/14 PD

3.0 D23273 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
2	D2327-3	Bushing	B37541

PD 08-07-14

4.0 D2506 Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part number	Description	Batch
1	D2506	Label Plate	B37446

PD 08-07-14

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
03.07.15	1	ADD 02979 REV B to w/o	PH	03.07.15	BL2	PH 03.07.15	N/17

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Date: Monday, 1/7/2008 11:36:23 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 36603C

Part Number: D3267041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number

Description

Batch

2 D2581

Mounting Brackets

B39046

PD 08-07-18

6.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 8.1900 sf(s)/Unit Total : 8.1900 sf(s)

Pick:

Qty Part number

Description

Batch

7.8sf M304EX0.75-16F

Expanded Metal

M108474 (7.1500) M108152 (1.1)

SAN 08/07/15 (1)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing as per Dwg D3267

2-Cut (4) D2236-1 From D3166-3

3-Drill holes in tubing D3267-041 as per Dwg D3267

4-Deburr & Remove All Markings From Material

SAN

08/07/15

(1)

5-Weld D3267-041 Assembly using Welding Table and corner Jig as per Dwg D3267. Deburr as required

Note: Expanded metal "diamonds" must run lengthwise. Eg 2.0" along length of lid.

PD 08-07-18 (1)

6-Drill Ø0.257" hole in D3267-041 as per Dwg D3267/Identify as D3267-041

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/07/23 1

9.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

08/07/23 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 11:36:23 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 36603C

Part Number: D3267041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

POWDER COATING

POWDER COATING



M108523



(1X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m. 08/07/23

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



~~M108523~~



Comment: HAND FINISHING RESOURCE #1

Wing walk as per Dwg D3267 and QSI 005 4.4

Spray Paint Black: M 108390

Wing Walk: M 108496



PL 08-07-23 ①

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Powder Coat and Wing Walk

F2 08/07/23 ①

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/24

Job Completion



u 08-07-24

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN DS	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3267	REV. B SHEET 1 OF 2
DATE 05.06.08		TITLE BASKET LID ASSEMBLY	SCALE NTS
A	04.02.02	NEW ISSUE	
B	05.06.08	ADD SHIM UNDER HINGES	

RELEASED

05.08.19 *[Signature]*

**PARTS LIST:**

Qty -041	Qty -043	Part Number	Description
X		D3267-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D3267-043	BASKET LID ASSEMBLY (INSIDE)
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	2	D3182-1	HINGE
2	2	D3265-3	STRUT
1		D3266-7	STRUT
2		D3267-1	STRUT
	2	D3442-3	SHIM

**NOTES:**

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.060 WALL SQUARE TUBING (REF. DART SPEC M304TS0.750W0.060)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC M304EX0.75-16F)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4. SPRAY PAINT  
INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

0.065 ~~PER~~ 06.07.15  
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 36603C

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

SHOP COPY  
 RETURN TO  
 ENGINEERING  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 WITHOUT NOTICE  
 WORK ORDER  
 360030

SKIN BASKET LID WITH 3/4-16F EXPANDED SS, TACK WELD EACH END STRAND TO EXTERNAL FRAME

D2506 LABEL PLATE CENTER ON THE BASKET

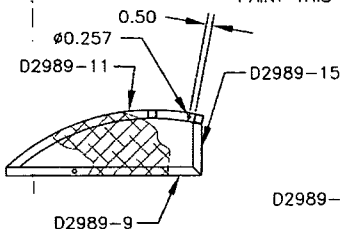
REMOVE 2" x 6" SECTION OF MESH FROM BEHIND LABEL PLATE

SEE DETAIL C (TYPICAL 2 PLACES)

TACK WELD EVERY 2ND STRAND TO INTERNAL FRAME MEMBERS

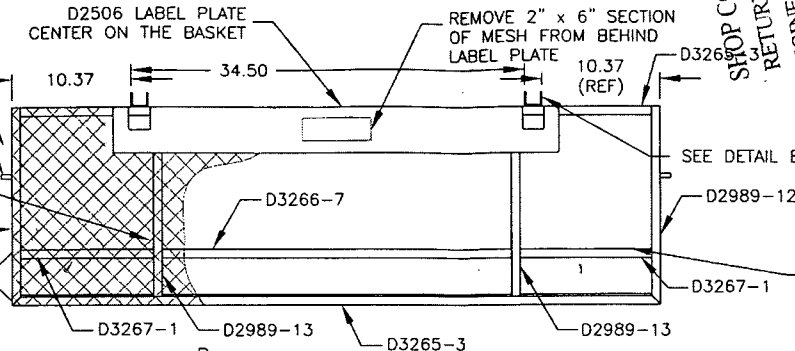
D2989-11 (REF)

BLACK ANTI-SKID PAINT THIS SECTION

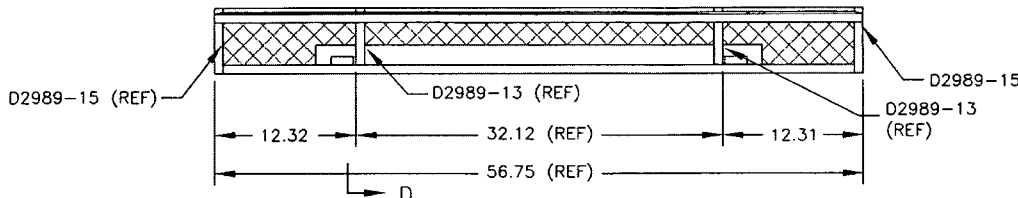


RELEASED

05.08.19



D



D3267-041 LID ASSEMBLY

SEE DETAIL A

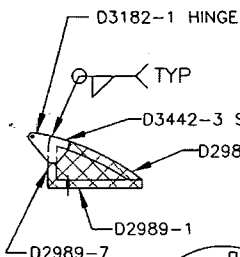
TACK WELD EVERY 2ND STRAND TO INTERNAL FRAME MEMBERS

D2989-3 (REF)

D3265-3

D2989-4

SKIN BASKET LID WITH 3/4-16F EXPANDED SS, TACK WELD EACH END STRAND TO EXTERNAL FRAME



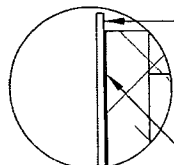
0.257 (TYP 5 PLACES)

D2989-3

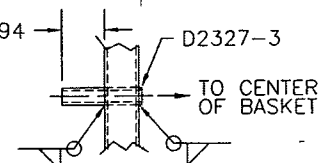
1.750 (TYP 2 PLACES)

DETAIL E

DETAIL E (SCALE 1:2) (TYP BOTH ENDS)

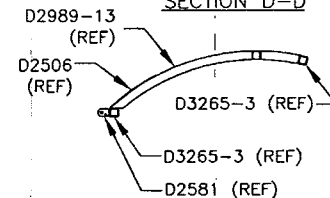


D3267-043 LID ASSEMBLY

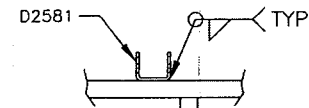


DETAIL C SPACER INSTALLATION

SECTION D-D



DETAIL A WELD ALL JOINTS AS SHOWN



DETAIL B

COPYRIGHT © 2004 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

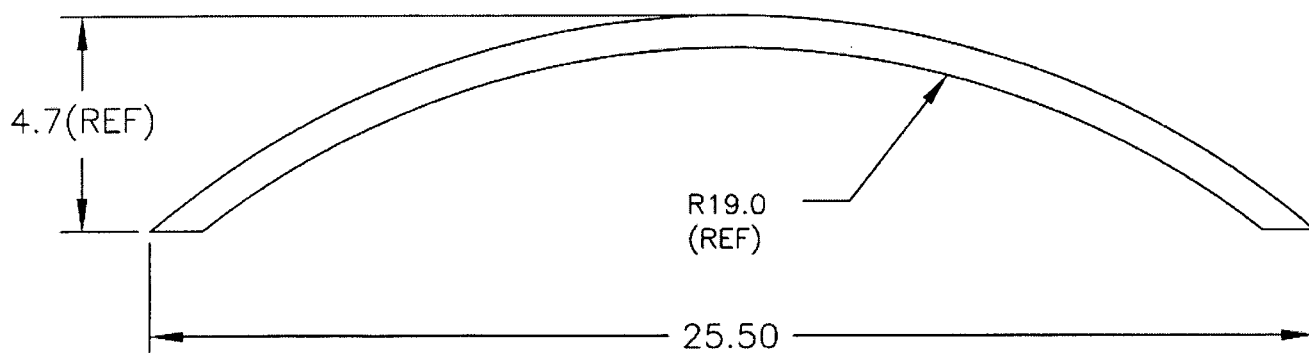
DESIGN	DS	DRAWN BY	PH	<b>DART</b>	DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED	PH	APPROVED	PH	DRAWING NO.	D3267
DATE	05.06.08	TITLE	BASKET LID ASSEMBLY	REV. B	SHEET 2 OF 2
				SCALE	1:10



DESIGN BW	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2236	REV. C SHEET 1 OF 1
DATE 05.06.07		TITLE LID RIB	SCALE 1:4
A	94.05.30	NEW ISSUE	
B	94.12.16	LID	
C	05.06.07	UPDATE NOTES, CHANGE RADIUS TO 19.0	

RELEASED

05.08.19 [Signature]



**D2236**

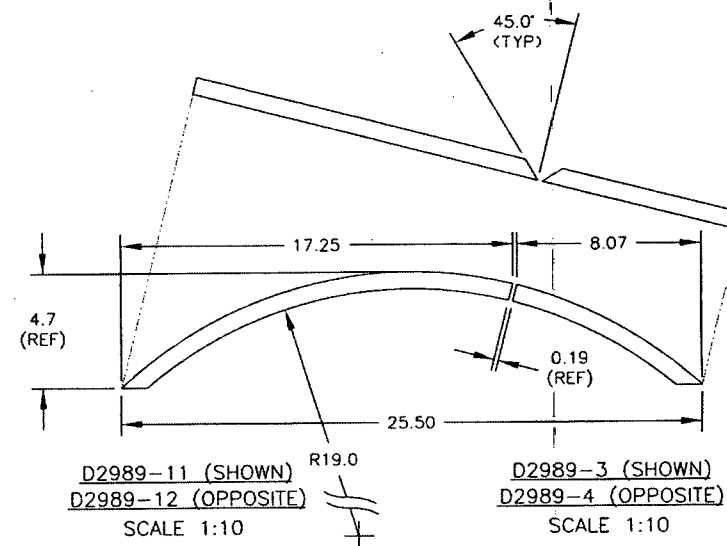
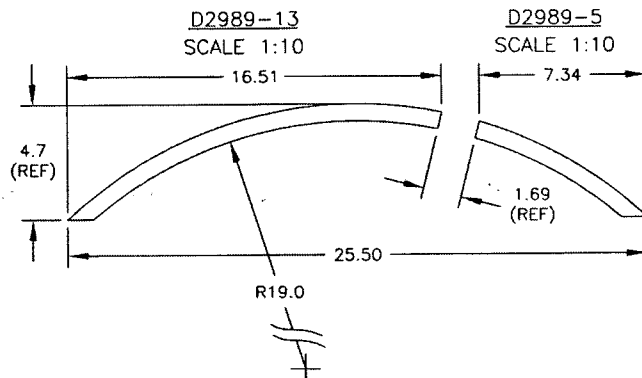
**D2236 LID RIB**

- 1) MAKE FROM D3166-3 BASKET HOOP
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES AER PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36603C

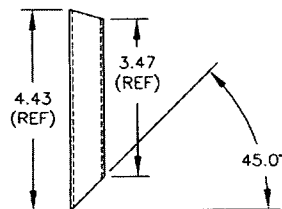
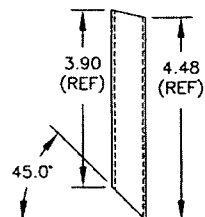
Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

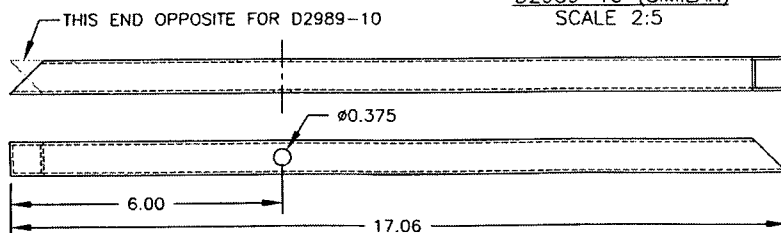


**D2989-15**  
SCALE 2:5  
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)

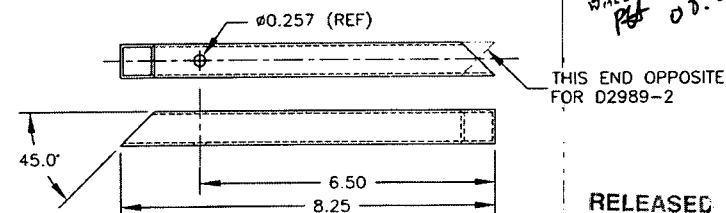
**D2989-7**  
SCALE 2:5  
(DIMENSIONS LISTED AS REFERENCE ONLY, CUT TO FIT ASSEMBLY)



**D2989-9 (SHOWN)**  
**D2989-10 (SIMILAR)**  
SCALE 2:5



**D2989-1 (SHOWN)**  
**D2989-2 (OPPOSITE)**  
SCALE 2:5



COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN DS	DRAWN BY PH	<b>DART</b>	DART AEROSPACE LTD. WARRICKSBURY, OXFORD, CANADA	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED #	APPROVED #	DRAWING NO. D2989	REV. B SHEET 3 OF 3	SCALE 1:10
DATE 05.06.07		TITLE BASKET LID ASSEMBLY		SHOP COPY		

RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36603



Date: Monday, 1/7/2008 11:36:07 AM  
 User: Kim Johnston

## Process Sheet

5

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 350 BASKET BASE (SHORT)
Job Number : 36603A	
Estimate Number : 10209	
P.O. Number :	Part Number : D3265041
This Issue : 1/7/2008 S.O. No. :	Drawing Number : D3265 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 36304A	Material :
Written By :	Due Date : 1/31/2008 Qty: 1 Um: Each
Checked & Approved By : <u>08.01.07</u>	
Comment : Est Rev:0 Re-Format 05-11-03 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D31661	Basket Hoop
-----	--------	-------------



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Qty 3 D3166-1 Basket Hoop Batch: B340090

SAD 02/07/14

①

2.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
-----	----------------	--------------------------



Comment: Qty.: 19.2150 f(s)/Unit Total : 19.2150 f(s)

3/4" x 3/4" x 0.063" wall 304/316 SS tubing.

(M304TS0.750W.065)

~~M108003~~ ) M108550 (7.965)

Batch: M108250 (11.25)

SAD 08/07/14

①

3.0	D22323	Basket Hinge
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2232-3

Hinge bracket

B39334

PD 08-07-18

4.0	D2325	Support Gusset (350 Bask
-----	-------	--------------------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 D2325

Support Gusset

B38741

PD 08-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 1/7/2008 11:36:07 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 BASKET BASE (SHORT)

Job Number: 36603A

Part Number: D3265041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D23273

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2327-3

Bushing

B37541

PD 08-07-18

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2581

Mounting Bracket

B40086

PD 08-07-18

7.0

D34425

Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3442-5

Shim

B24246

PD 08-07-18

8.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 26.0000 sf(s)/Unit Total : 26.0000 sf(s)

Pick:

Qty Part Number

Description

Batch

26sf

M304EX0.75-16F

Expanded Metal

M108474 (23)

M108162 (2)

SAD 08/07/14

①

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-CUT (3) D2235-1 FROM D3166-1

SAD 08/07/14

①

2-Drill hole in D3265-3 as per Dwg D3265

3-Remove all markings from material

SAD 08/07/15

PD 08-07-18

①


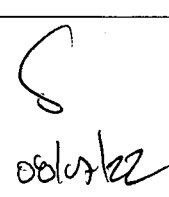
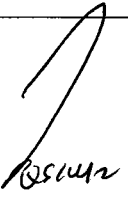
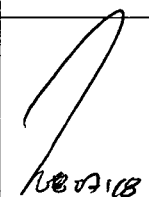
4-Weld as per Dwg D3265 using Welding Table and corner JigDeburr as required

# Dart Aerospace Ltd

W/O: 36603A		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3265-041 PAR #: \_\_\_\_\_ Fault Category: Large Fals NCR: Yes ☒ No ☐ DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 36603A		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
0807	9.0	During welding, it was noticed that the D3265-5 had a line across the material. SEAM was very visible. R.C: Not a good Finish From supplier.		Remove & replace the -5. Qty 1 m <del>108550</del> and weld as per Dwg. Inspect the -5.	PD 08-07-18			

NOTE: Date & initial all entries

Date: Monday, 1/7/2008 11:36:07 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350 BASKET BASE (SHORT)

Job Number: 36603A

Part Number: D3265041

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/07/23

11.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

08/07/23

12.0

POWDER COATING

POWDER COATING



M108523



(1X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1 08/07/23

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-07-23

14.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: Small Medium Fab

Seal support gusset seam with White Sikaflex-291

Batch: 11107804

Expiry date: 10/2008

08/07/24

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/24

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

PPP 36603 08/27/24

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/24

Job Completion



08.07.24

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

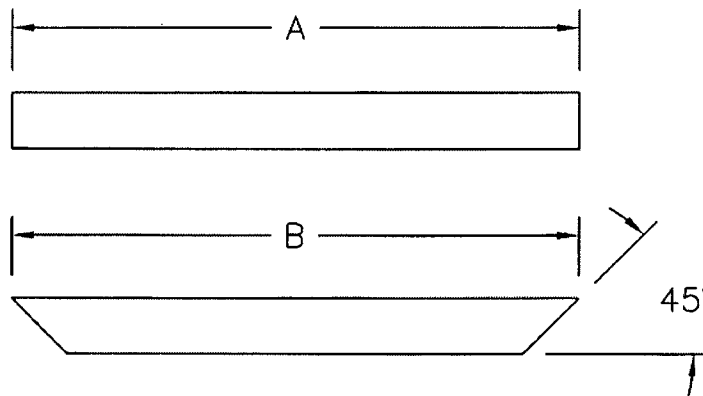
DESIGN DS	DRAWN BY PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3265	REV. B SHEET 1 OF 3
DATE 05.06.08		TITLE BASKET BASE ASSEMBLY (350)	SCALE NTS
A	04.02.02	NEW ISSUE	
B	05.06.08	ADD SHIM UNDER HINGES, ADD HOLES FOR SPLIT LID BASKETS	

**RELEASE**

05.08.19 H

PARTS LIST FOR D3265-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3265-1	2	—	56.75	RIB
D3265-3	2	—	25.50	RIB
D3265-5	2	27.25	—	RIB
D2232-3	2	N/A	N/A	HINGE PLATE
D2235-1	4	N/A	N/A	RIB
D2325	4	N/A	N/A	SUPPORT GUSSET
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MTG BRKT
D3442-5	2	N/A	N/A	SHIM



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO 36603A

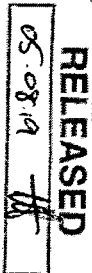
D3265-1/-3/-5

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.060 WALL SQUARE TUBING  
(REF. DART SPEC M304TS0.750W.060)
- 3) TOLERANCES ARE PER DART QSI-018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) DRILL  $\phi 0.257$  HOLES ONLY WHEN ASSEMBLING  
D3265-041 BASE WITH D3267-041/-043 LID

**Copyright © 2004 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

**DART AEROSPACE LTD**  
HAMKESBURY, ONTARIO, CANADA

1:20

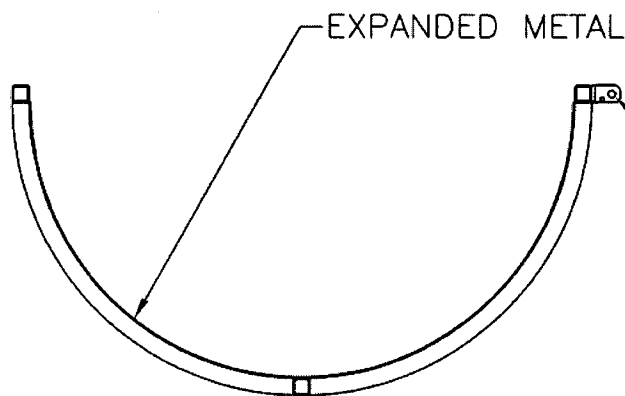
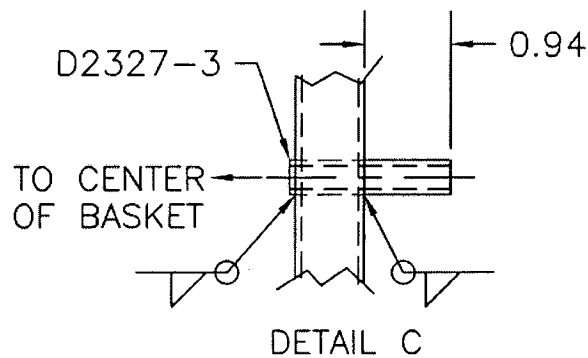
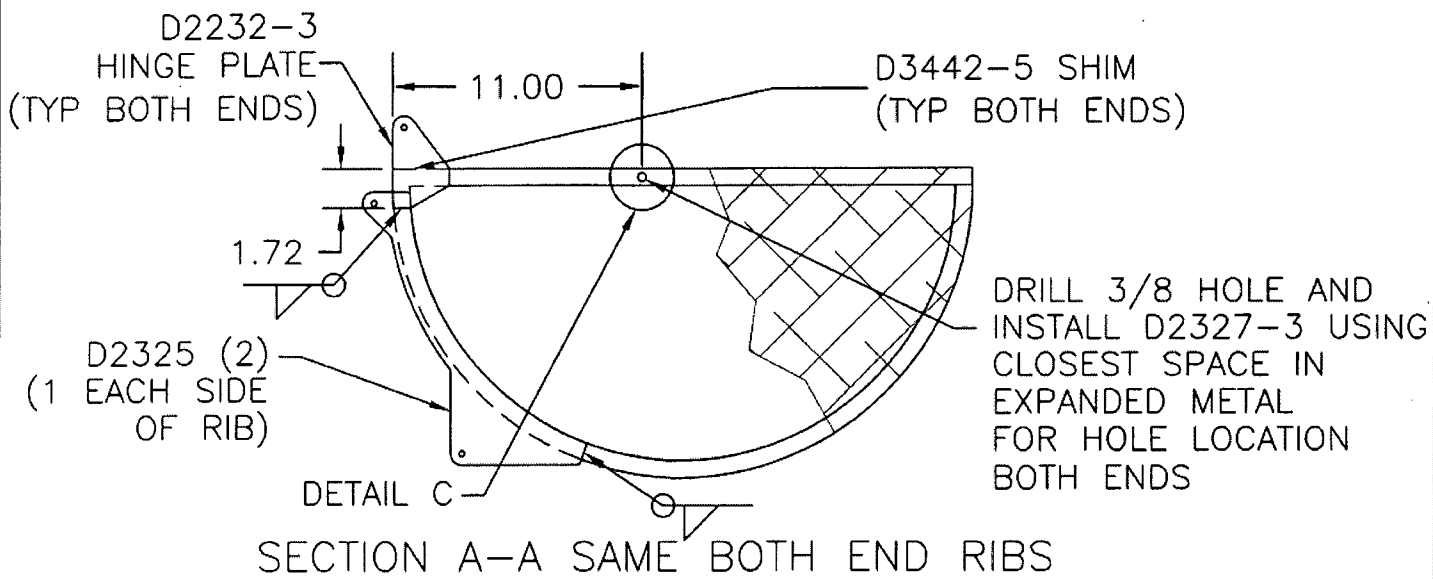
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
NOTICE

WORK ORDER 26603-A





DESIGN DS	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3265	REV. B SHEET 3 OF 3
DATE 05.06.08		TITLE BASKET BASE ASSEMBLY (350)	SCALE 1:8



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36603A

RELEASED

05-08-19 [Signature]

SECTION B-B SAME BOTH CENTER RIBS

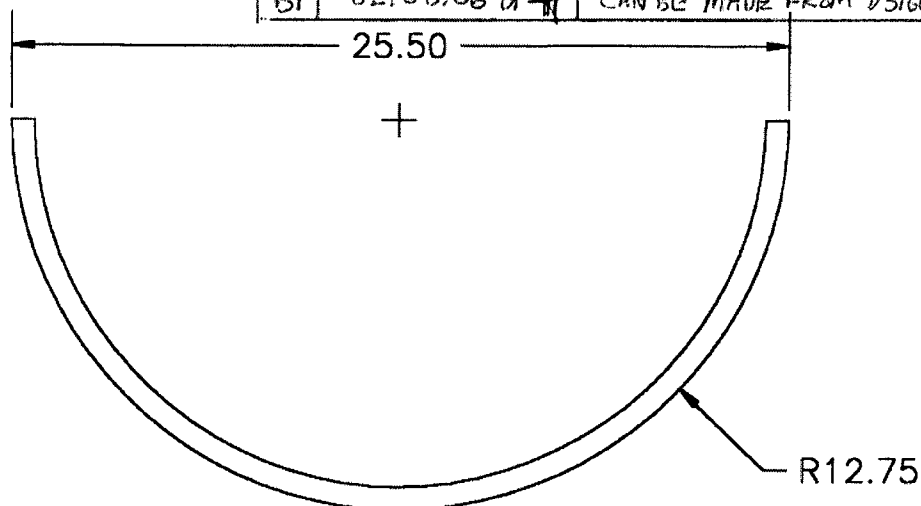
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

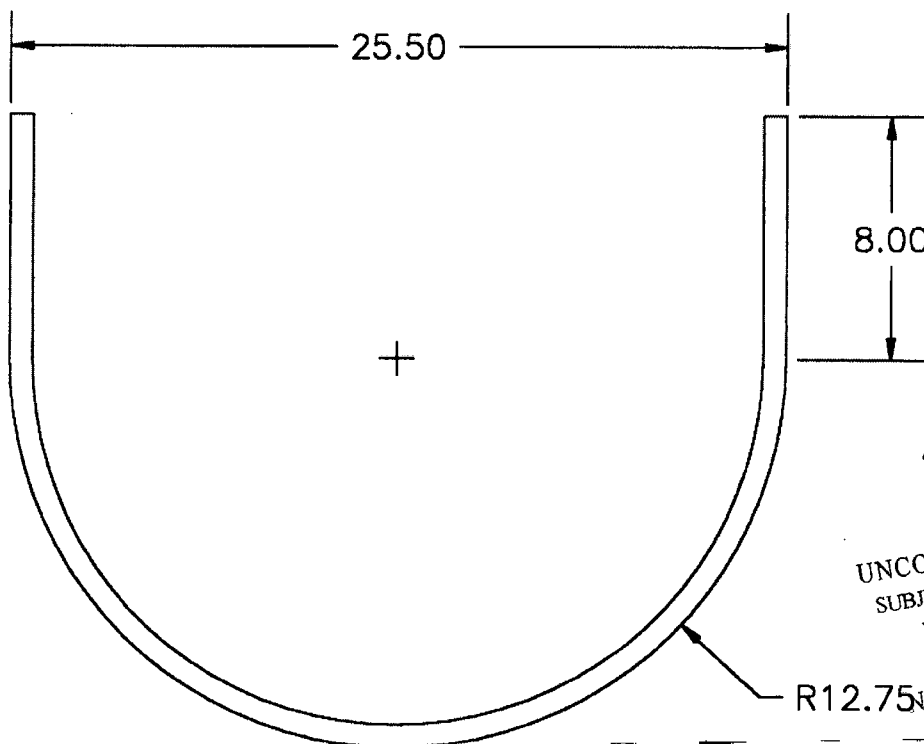


DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2235	REV. B SHEET 1 OF 1
DATE 94:12:16		TITLE BASKET RIBS	SCALE
BI	02.08.06 <i>[Signature]</i>	CAN BE MADE FROM D3166-1	

RELEASED  
R 960507



D2235-1



D2235-3

CAN BE MADE FROM D3166-1 *[BI]*  
MATERIAL: 304/316 SS, 3/4 X 3/4 X 0.063 WALL SQR.

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 36603A